

Work Order ID 66293

February 9, 2011 10:07:02 AM



Page 1

Item ID: D3609-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 2/10/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/24/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CMF

Date: 11-02-09 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3609

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3609

☐ Dwg Rev:

A

☐ Prog Rev:

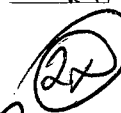
A

☐ 2-

Deburr if necessary

Deburr m/d 11/02/22

B11-2-16



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-16

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/11/22



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Doubler

Start Date: 2/10/11 Start Qty: 2.00



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Required Date: 2/24/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PM66292

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/02/22

11-02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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⚡ **NOTE:** Date & initial all entries

Picklist Print

February 9, 2011 10:07:01 AM

Page 1

Work Order ID: 66293



Parent Item: D3609-1



Parent Item Name: Doubler


Start Date: 2/10/11

Required Date: 2/24/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA  304/316 .032 Sheet		Purchased	No			100	sf	65.5296	1.1769	2.477684			



Bil-2-16

Location

Loc Qty

Loc Code

MAT20

65.5296

109023

30.2896

109057

35.24

109057

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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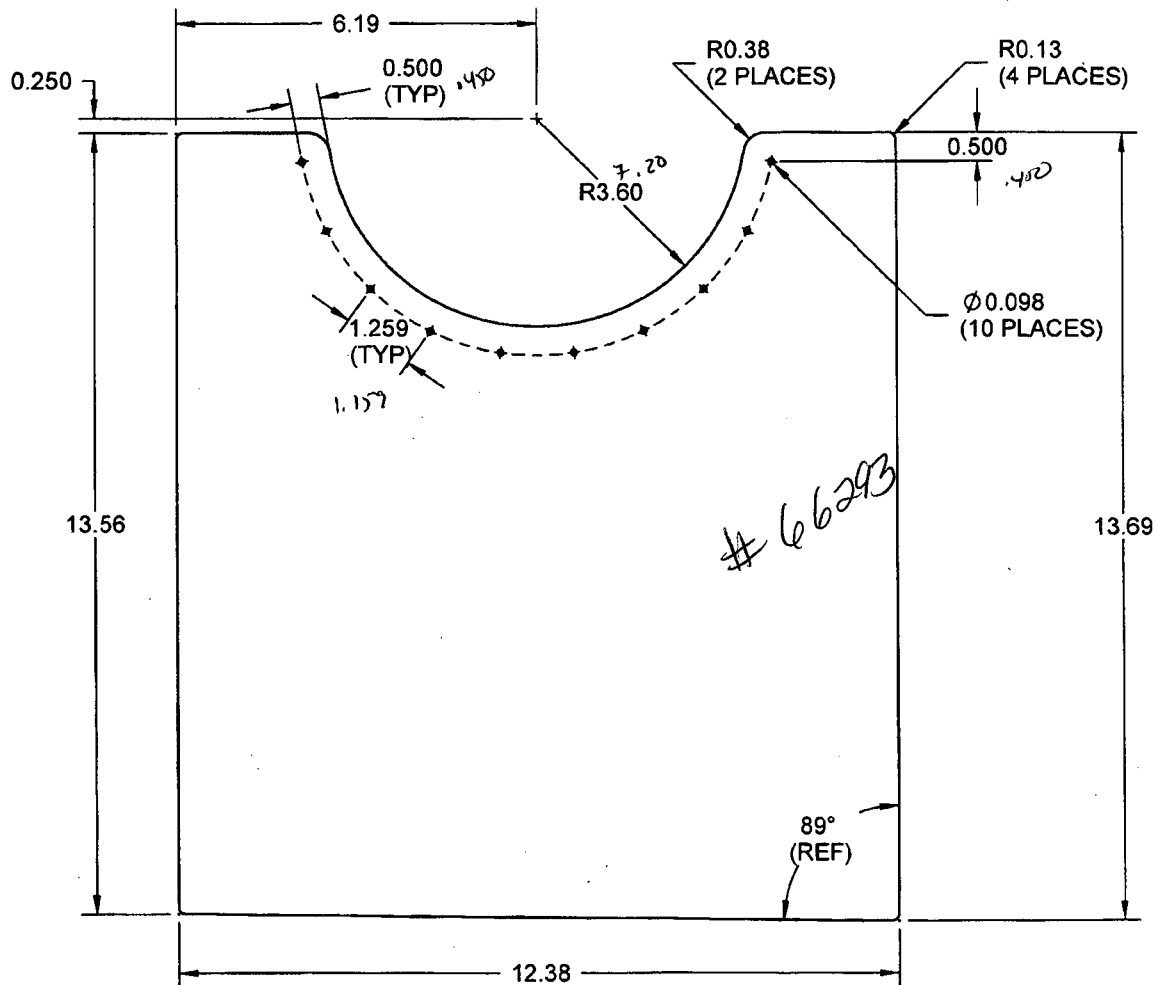
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3609	REV. A SHEET 1 OF 1
DATE 07.04.11		TITLE DOUBLER	SCALE 1:3
REV A	DATE 07.04.11	DESCRIPTION NEW ISSUE	

RELEASED
08/12/10 *[Signature]***D3609-1 DOUBLER****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3609-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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